

Date: Friday, 25/07/2008 4:20:47 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BRACKET |
| Job Number | : 40760 | | |
| Estimate Number | : 13512 | | |
| P.O. Number | : | Part Number | : D21961 |
| This Issue | : 25/07/2008 S.O. No. : | Drawing Number | : D2196 REV C |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : // Type : SMALL /MED FAB | Drawing Revision | : C |
| Previous Run | : | Material | : |
| Written By | : | Due Date | : 20/08/2008 Qty: 2 Um: Each |
| Checked & Approved By | JLD 08.7.25 | | |
| Comment | : Est Rev:A 08-07-24 new issue ec verified by:dd | | |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S16GA

304/316 Sheet.063



Comment: Qty.: 0.2216 sf(s)/Unit Total : 0.4431 sf(s)

304 SS Sheet 0.063" thick

batch: 108724 HB 8-8-21

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2196

Dwg Rev: C HB 8-8-21

Prog Rev: C

2-Deburr if necessary HB 8-8-21

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-8-21

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per dwg D2196

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Friday, 25/07/2008 4:20:48 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40760

Part Number: D21961

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/08/05 (+3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify wiith Dart part # using a fine point permanent marker and Stock

Location: 18

8/8/25

(3x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



W 08.08.26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

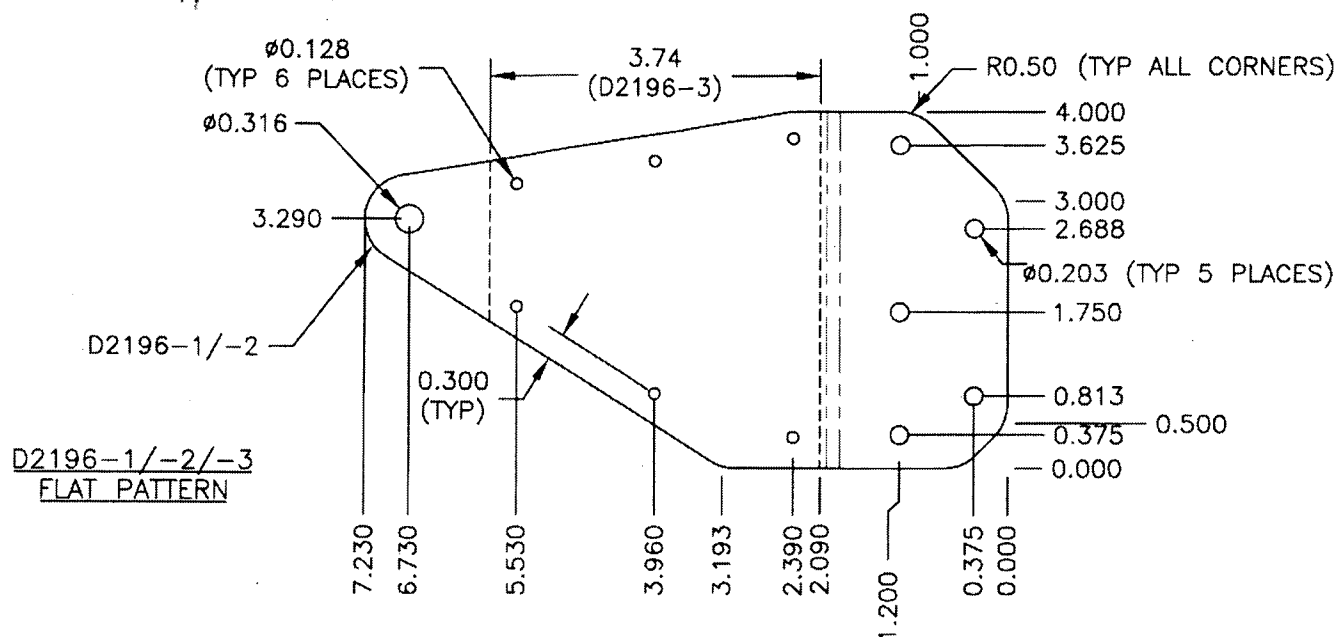
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| | | | |
|------------------|----------|---|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D2196 | REV. C SHEET 1 OF 1 |
| DATE 03.05.28 | | TITLE BRACKET | SCALE 1:2 |
| B | 93.09.23 | REDESIGN | |
| C | 03.05.28 | REDRAW; D2196-3 NOW 0.5" THICK | |



D2196-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2196-3

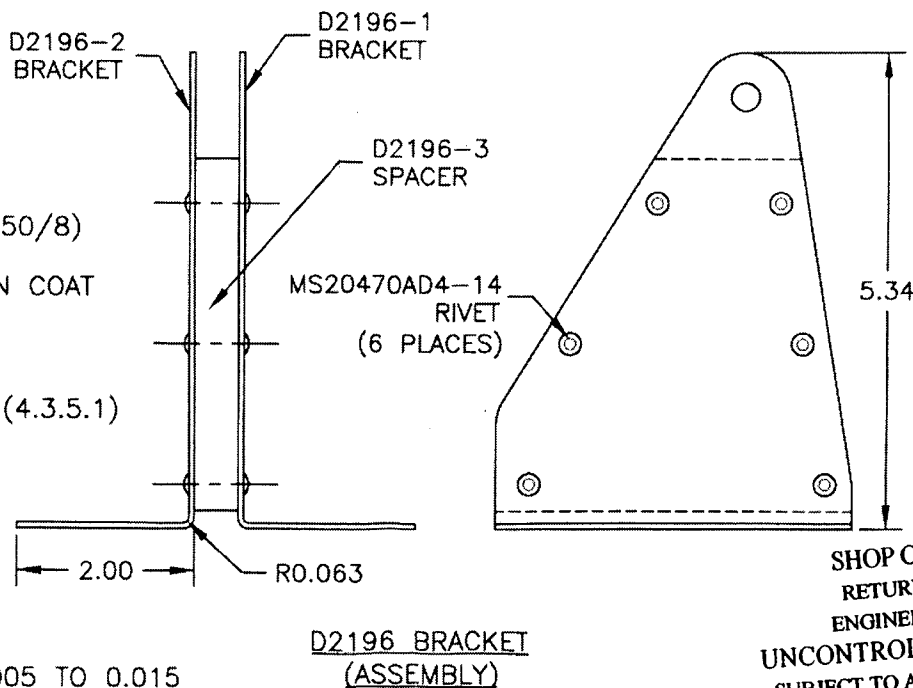
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2196 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

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NO. 40160

| | | |
|--|--|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 40760 |
| Description: BRACKET | | Part Number: D2196-1 |
| Inspection Dwg: D2196-1 Rev: C | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø .128 | + .005 - .001 | .129 | * | | | |
| Ø .203 | + .005 - .001 | .204 | * | | | |
| Ø .316 | + .006 - .001 | .317 | * | | | |
| .375 | +/- .010 | .375 | * | | | |
| .813 | +/- .010 | .813 | * | | | |
| 1.750 | +/- .010 | 1.751 | * | | | |
| 2.688 | +/- .010 | 2.689 | * | | | |
| 3.625 | +/- .010 | 3.626 | * | | | |
| 4.008 | +/- .010 | 4.004 | * | | | |
| .375 | +/- .010 | .375 | * | | | |
| 1.200 | +/- .010 | 1.200 | * | | | |
| 2.390 | +/- .010 | 2.385 | * | | | |
| 3.960 | +/- .010 | 3.960 | * | | | |
| 5.530 | +/- .010 | 5.530 | * | | | |
| 6.730 | +/- .010 | 6.732 | * | | | |
| 7.230 | +/- .010 | 7.232 | * | | | |
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| Measured by: RB | Audited by: S | Prototype Approval: 12/14 |
| Date: 8-8-21 | Date: 08/08/21 | Date: 12/14 |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

[Handwritten signature]

